

Date: Thursday, 14/08/2008 11:50:04 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-ACCESS STEP LH (FOLDING)
Job Number : 41243	
Estimate Number : 12567	
P.O. Number :	Part Number : D412630033
This Issue : 14/08/2008 S.O. No. :	Drawing Number : IIN D412-630
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : L
Previous Run : 41003	Material :
Written By :	Due Date : 21/08/2008
Checked & Approved By : <u>JLD 08-8-18</u>	Qty: <u>1</u> Um: Each
Comment : Est. Rev:A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by:DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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# for JLD 08.8.26



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-033 CHG003

508/12/16

2.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	<u>40274</u>

SS 08/12/11 (x2)

3.0	D2803041	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-041	Bracket Assembly LH	<u>41672</u>

SS 08/12/11 (x2)

4.0	D2804041	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-041	Bracket Assembly LH	<u>41054</u>

SS 08/12/11 (x2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

Door prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Support Prop

Batch:

35751

SS 08/12/11 (X2)

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 D2813

Washer

34020

SS 08/12/11 (X2)

7.0

D3562041

Step Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Step Weldment LH

Pick:

Qty Part Number

Description

Batch

1 D3562-041

Step Weldment LH

B41648

SS 08/12/12 (X2)

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick:

Qty Part Number

Description

Batch

4 D3395-1

Bushing

41035

SS 08/12/12 (X2)

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

2 AN3C21A

Bolt

M10189

SS 08/12/11 (X2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 41243

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M105969  
~~109564~~

SS 08/12/11 (2)

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M106431

SS 08/12/11 (2)

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M106763

SS 08/12/11 (2)

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M107101

SS 08/12/11 (2)

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M104956

SS 08/12/11 (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Pick:

Qty Part Number Description  
4 NAS1515H8 Washer

Batch

M109099

SS 08/12/11 (x2)

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nut

Pick:

Qty Part Number Description  
4 MS21043-3 Nut

Batch

M109535

SS 08/12/11 (x2)

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

Pick:

Qty Part Number Description  
2 MS24693-C280 Screw (or MS24694-C565)

Batch

M101390

SS 08/12/11 (x2)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON BATCH: M104251

SS 08/12/12 (x2)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 08/12/12 (x2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

35630

SS 08/12/11 (R)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

36534

SS 08/12/11 (R)

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

40900

SS 08/12/11 (R)

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

34025 x1 41670 x3

SS 08/12/11 (R)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

109147

SS 08/12/11 (R)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

*Handwritten:* M101189, 08/12/11, (initials), ~~M105940~~, ~~M104679~~

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

*Handwritten:* M107082, 08/12/11, (initials)

28.0

AN4C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C7A

Eyebolt

*Handwritten:* M109013, 08/12/11, (initials)

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

*Handwritten:* M105125, 08/12/11, (initials)

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 14.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

*Handwritten:* M108880, 08/12/11, (initials)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 41243

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 14.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

M168334

SS 08/12/11 @

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M1091600

SS 08/12/11 @

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

M109535

SS 08/12/11 @

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/12/16 (X) LH

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location: 111

PPP Rev: A

8/12/16

Label checked SS

SP

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/16

Job Completion



U 08/12/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

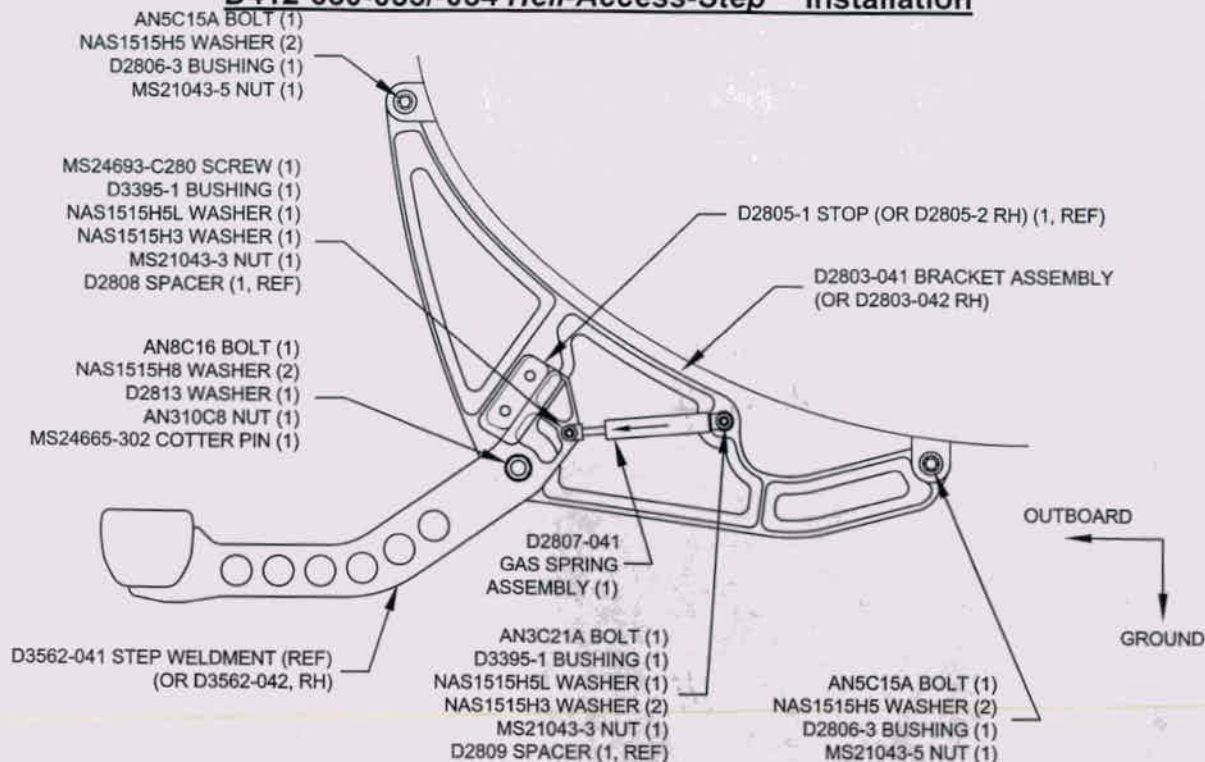
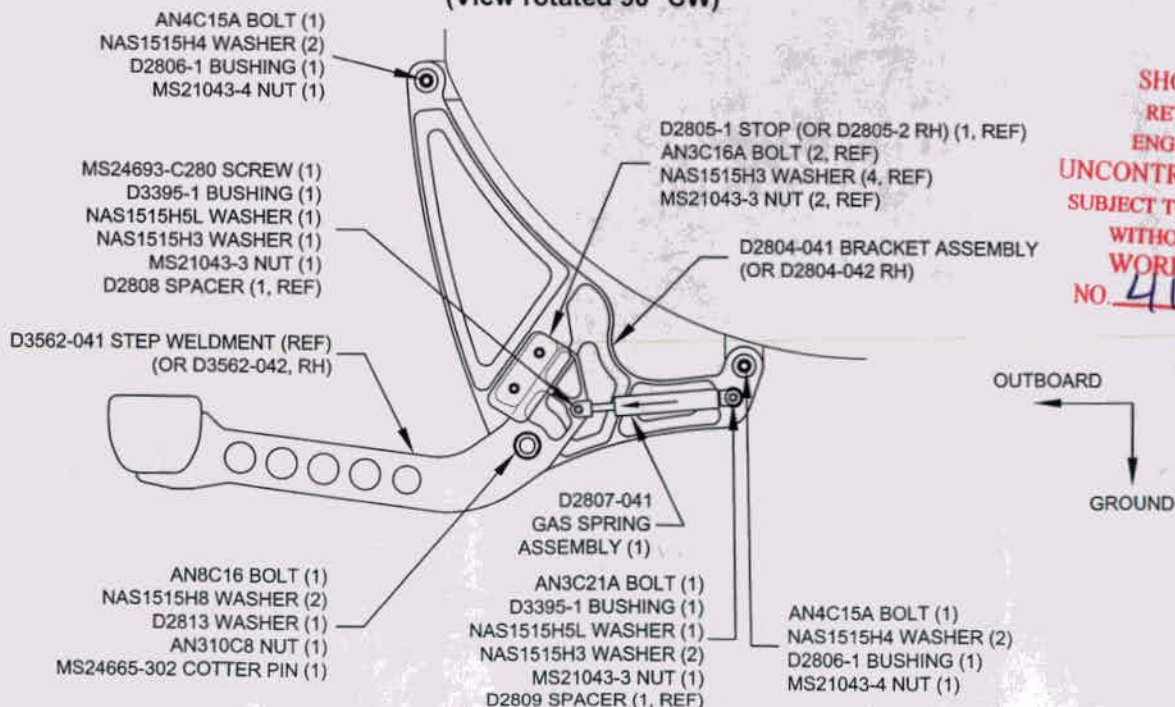
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

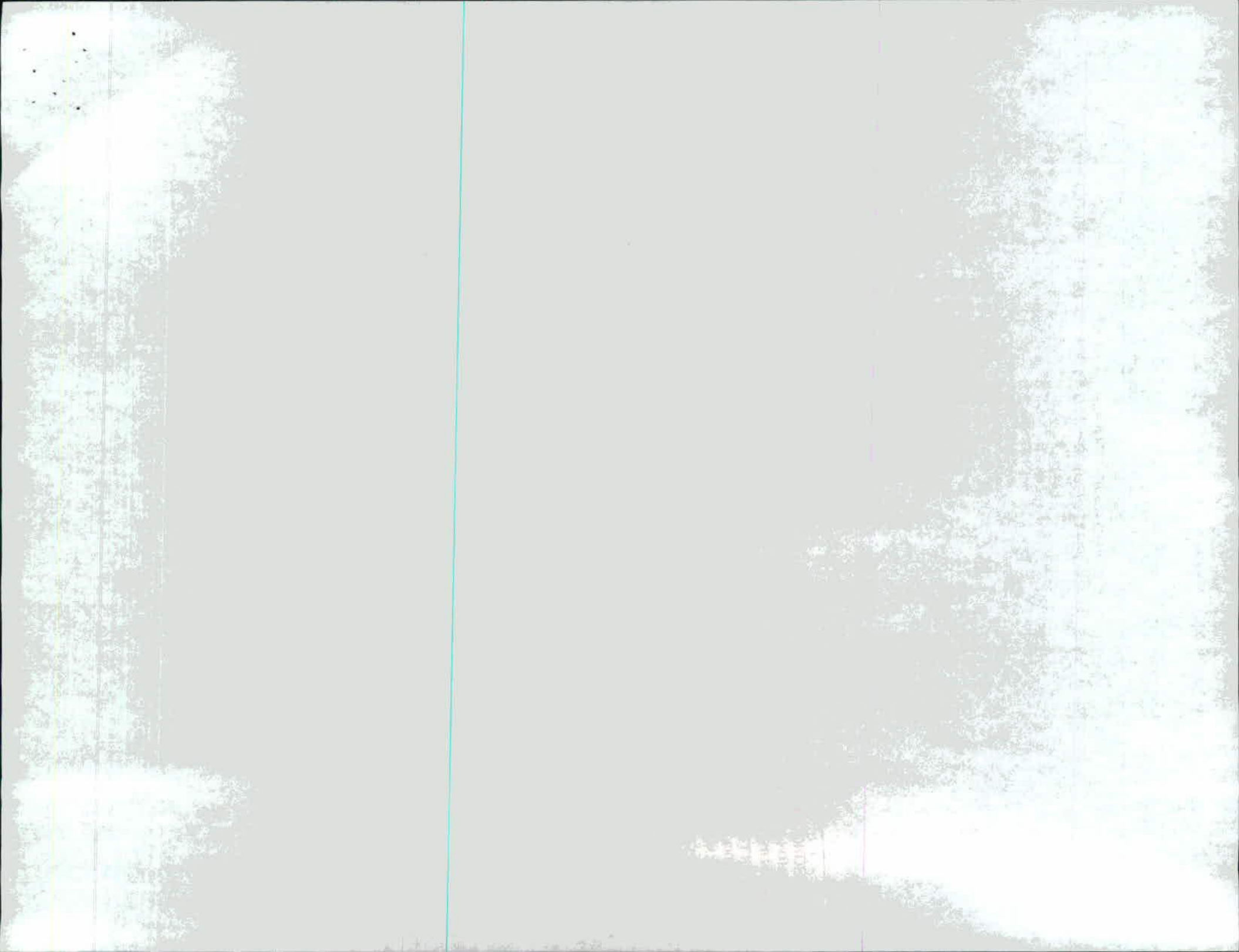
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**D412-630-033/-034 Heli-Access-Step™ Installation****FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41243





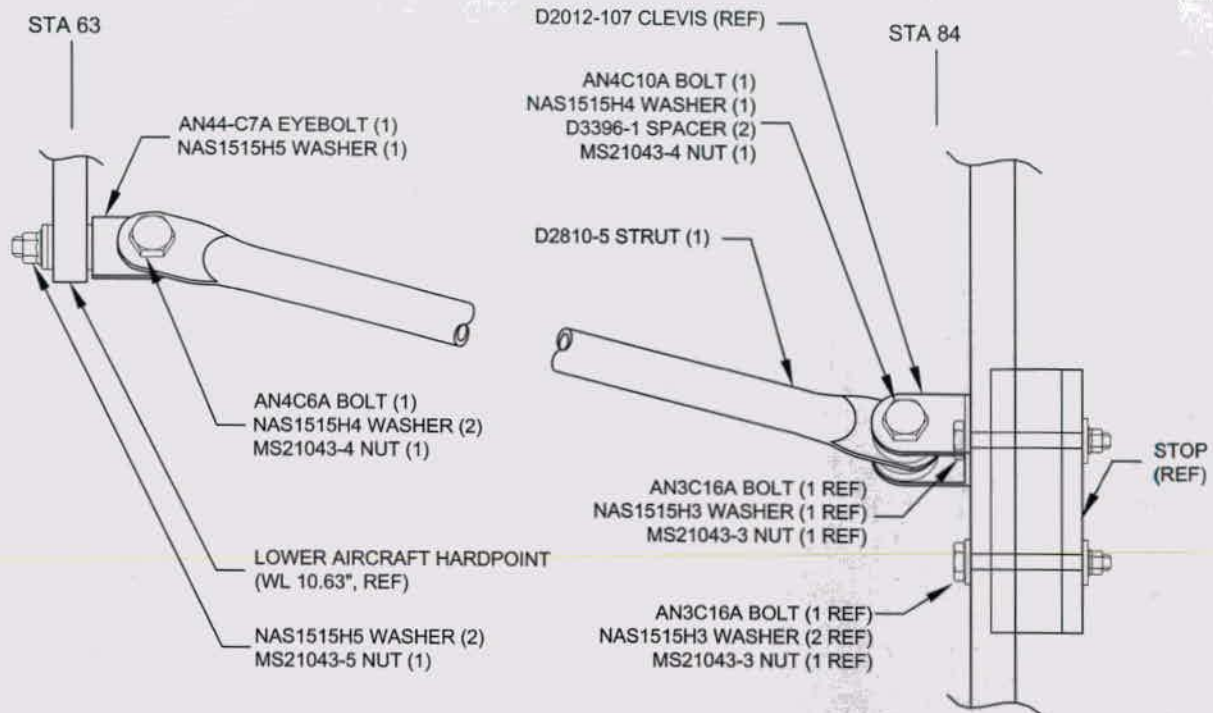
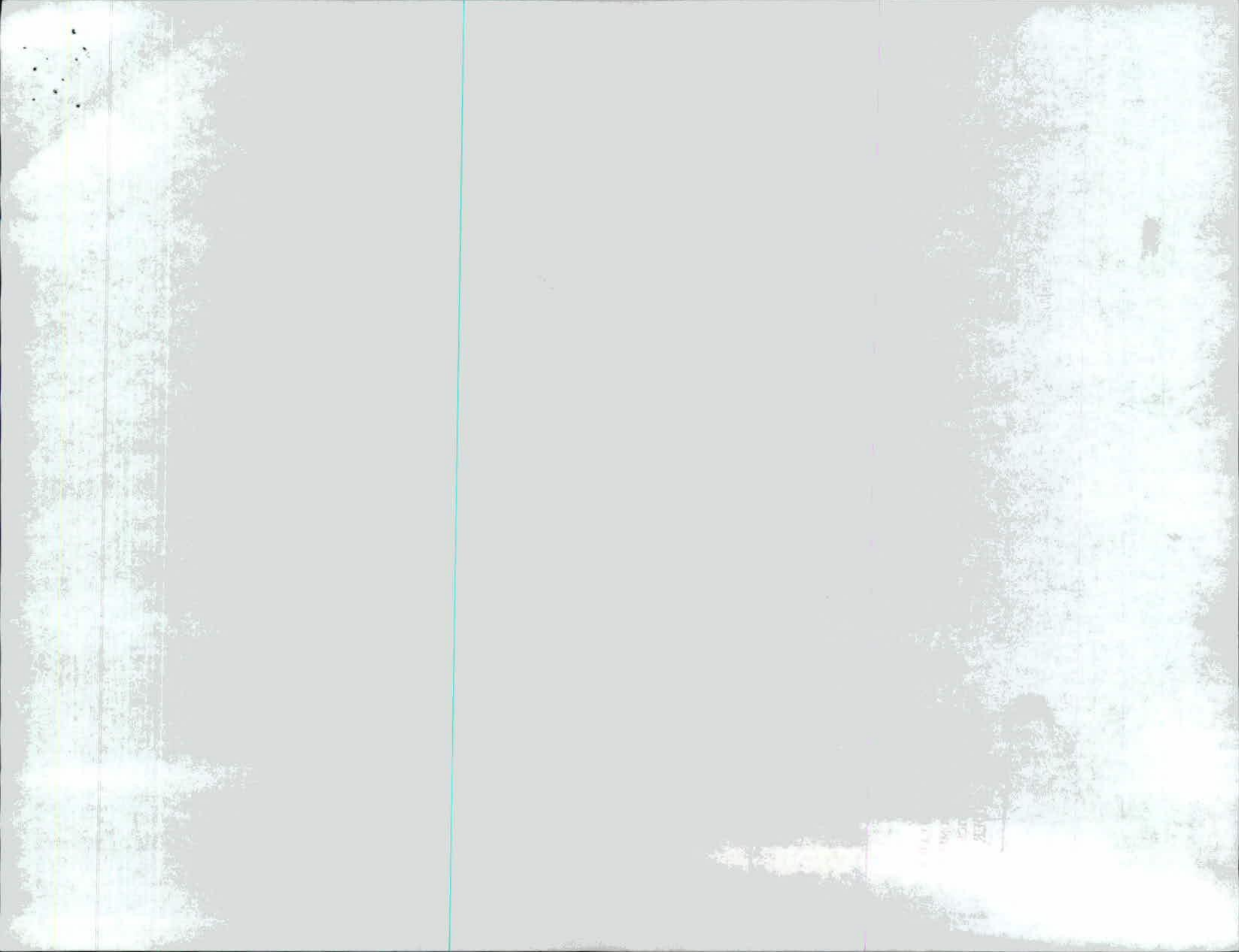


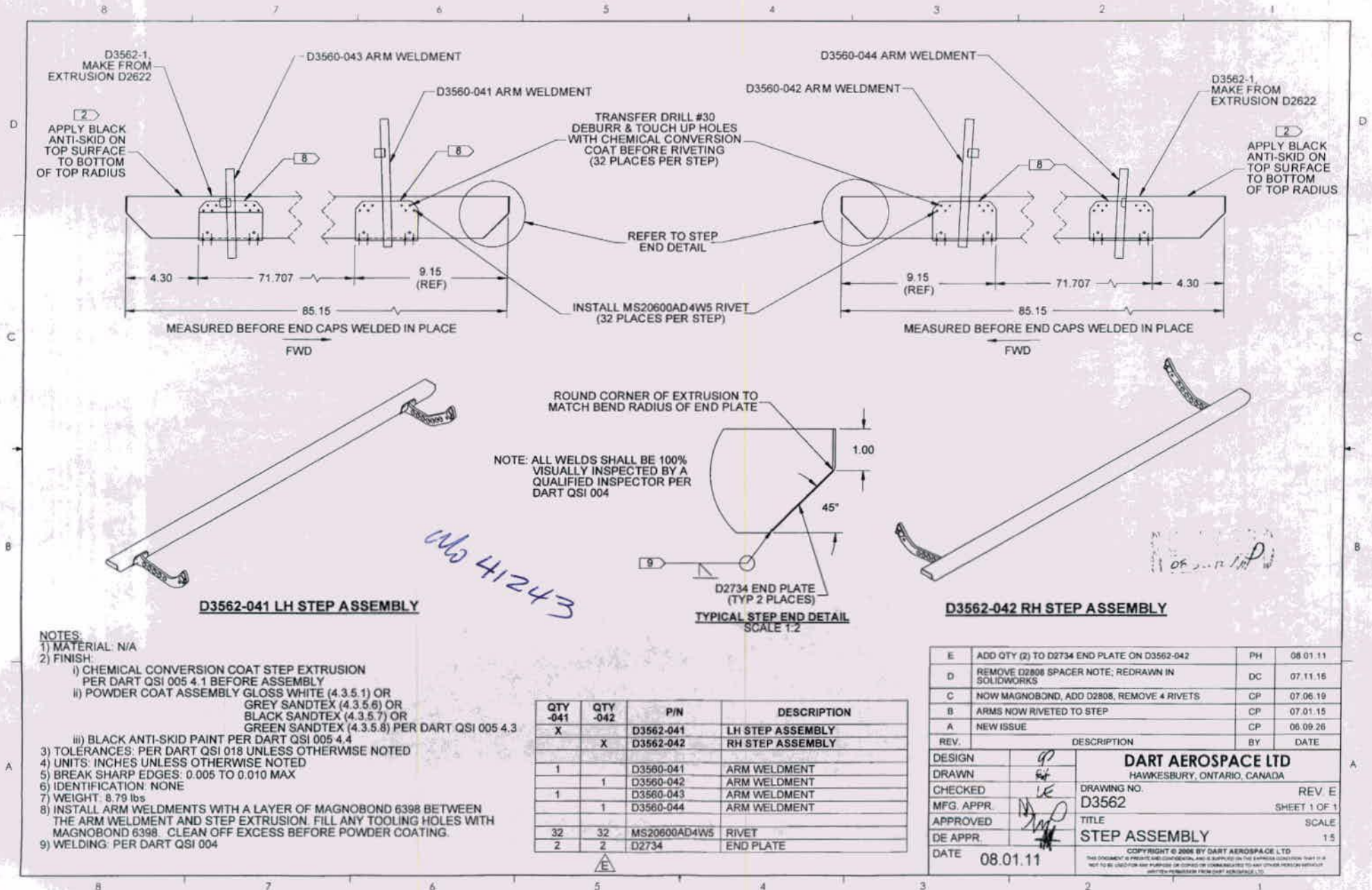
FIGURE 16 – Strut Detail for D412-630-033/-034 *Heli-Access-Step™* Installation  
(NOT TO SCALE)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41243





# REFERENCE ONLY



REFERENCE ONLY